

What is claimed is:

1. A system for designing a virtual Kanban system usable with a manufacturing execution system comprising:
 - means for inputting a plurality of operating requirement parameters to define a Kanban system model;
 - a database for storing said model; and
 - simulating means for simulating said mdoel;wherein said simulating means calculates start and end of each Kanban stage in said Kanban system and the number of cards for each Kanban stage based on said model.